

69.

5/29

DART AEROSPACE LTD	Work Order:	23689
Description: Lug	Part Number:	D2591
Drawing: D2591 Rev. D	Qty:	100 99

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JF	05.06.27	100
2	METAL	Cut blanks: 2.700" long Material: ASTM A36 steel bar 2.50" X 0.75"" thick			
3	HAAS	Machine per Folio FA039	m17664	05.07.05	100
4	QC	Inspect Level 2	SD	05.07.12	99
5	QC	Inspect Level 8	SD	05.07.13	99
6	METAL	Tumble	N/A		
7	METAL	Deburr after tumbling if necessary	SD	05.07.13	99
8	QC	Inspection Level 5	EC	05.07.13	99
9	STORES	Identify and Stock	AP	05.07.13	99
10	EXPEDITING	Close W/O 5.69 Inspection Level 21 Cost/part: 5.69	JF	05.07.15	99
			JF	05.07.14	99

Rev	Date	Change	Revised By	Approved
C	98.01.21	Changed Rev of Dwg	BW	
D	98.04.17	Re-format	KB	
E	99.07.06	Re-format, Added bevel	DM	
F	99.09.14	Remove bevel, added tumble	EC	
G	00.03.15	Now goes on Haas	EC	
H	01.11.29	Reformat	SM	EC

RELEASED

R 01.11.30

UNDER REVIEW

03.06.05 RF

combine with

D205-641-01C

A DSI 9161

R 01.12.01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-07-13	6	Remove permanently	JM	05-07-14	NA	BB 05-07-14	BB 05-07-14	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-07-13	3	part came out of vise	BB 05-07-13	destroy	SA 05-07-13	BB 05-07-14	BB 05-07-14	BB 05-07-14

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA:

Date: 05/07/14

NOTE: Date & initial all entries

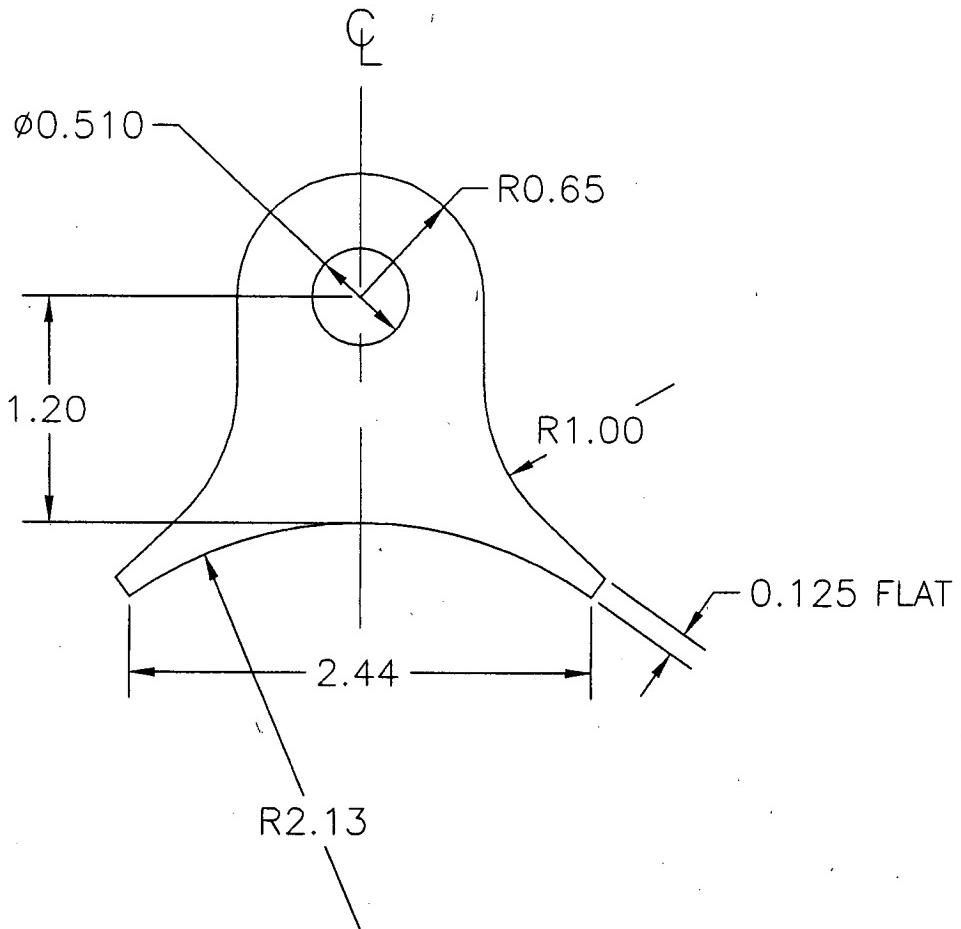
QA: N/C Closed: _____

Date: _____



DRAFT

DESIGN <i>DWY</i>	DRAWN BY <i>DWY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

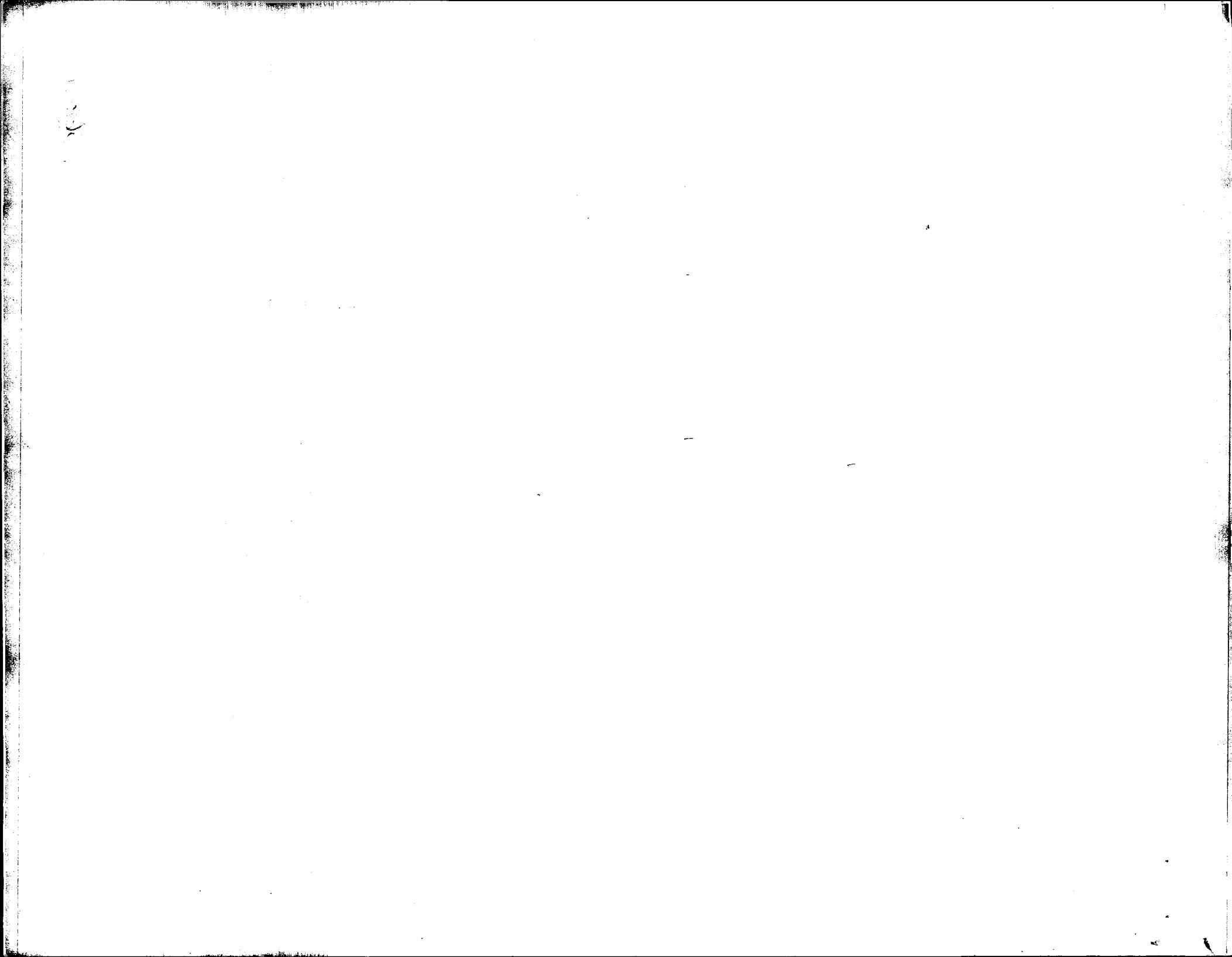
RELEASED
98.01.21 DS

BREAK ALL SHARP CORNERS 0.010 TO 0.020
 MATERIAL: ASTM A36 STEEL 0.50 THICK
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 PART IS SYMMETRIC ABOUT CENTER-LINE
 ALL DIMENSIONS ARE IN INCHES

00-04-05
 0.063
 SHOP COPY
 RETURN TO
 ENGINEERING

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE

WORK ORDER
 NO 23689



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 27, 2005
08:10 am

Work Order No	:	0023689	Department Code:	
Project Name	:	D2591	Burden Flags	: NNNNNNN
Project For	:	WK529	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D2591	Invoice Number	:
Description	:	Lug	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	100	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	06-27-05	Est Mark Up	: 0.000%
Est Finish Date	:	07-25-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>	<hr/>	<hr/>	<hr/>		
Burden	: 0.00	0.00	0.00		
<hr/>	<hr/>	<hr/>	<hr/>		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD	Work Order:	23689
Description:	Part Number:	D8591
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	TSG	Audited by:	EP	Prototype Approval:	N/A
Date:	05.07.16	Date:	05/07/16	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	